

**Work Order ID 85138**

June-04-12 1:25:41 PM

**\*85138\***

Page 1

Item ID: D350-636-011

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Stop

**\*NS2\***

Item Name: Skidtube LH

Start Date: 04/06/2012 Start Qty: 1.00 **\*1\***

Cust Item ID:

Required Date: 18/06/2012 Req'd Qty: 1.00 **\*1\***

Customer:

Reference:

Approvals: Process Plan: MLJDate: 12/06/04 Tooling:

Date:

Run Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2750	F								
D3492	C								

100  
**\*100\***

DOCUMENT CONTROL

0.00

12/06/04  
12/06/04  
JBDC  
Document Control

Memo

0.00

Photocopy blue file and type labels per PPP D350-636-011 CHG 006

MW 12/07/11

**B85138L1-1**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Work Order ID 85138**

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Item ID: D350-636-011

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**\*85138\***

Revision ID:

Item Name: Skidtube LH

Start Date: 04/06/2012 Start Qty: 1.00 **\*1\***Required Date: 18/06/2012 Req'd Qty: 1.00 **\*1\*****\*N900040100\***

Setup

Start

**\*NS1\***

Stop

**\*NS2\***

Reference:

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	<b>*NR1*</b>
	QC:	Date:	SPC (Y/N):	Date:		Stop	<b>*NR2*</b>

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110	Skidtubes	0.00							

**\*110\***

Skidtubes

Memo

1- Pick D2600-3 Bent

*BE 12/06/25*2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside  
AFT end per dwg D2750*BE 12/06/25*3- Drill pilot holes for blade fitting bolt holes using DT8983. Open to 0.500",  
debur.*7**SAD 12-06-28*4- Locate DT8330 off of blade fitting bolt holes and drill pilot holes for blade  
fitting*3**SAD 12-06-28*

5- Drill only two fwd step holes using DT9616. Ensure proper positioning.

*8**BE 12/06/25*6- Drill pilot holes as per Dwg D2750 sheet 4 (D2750-1 details).Drill using drill  
Jig DT8150 & DT8863A for first side only DT8863B for second side (detail B)*7**SAD 12-06-28*7- Clecko DT8863B on second side of tube and drill pilot holes for detail B.  
\*\*\*SECOND SIDE\*\*\**8**SAD 12-06-28*8-Open up holes for Detail B to 0.375" (4 holes per side)and blade fitting  
location holes to 0.500" (total of 4 holes per side) as per dwg D2750 .Open up  
holes for ground handling and detail C to 0.500" (8 holes per side)*9**BB 12/06/28*9-Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to  
0.297".

10-Open up holes of Detail A to 0.297" (total of 2 holes per side)

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Revision ID:

Item Name: Skidtube LH

Start Date: 04/06/2012 Start Qty: 1.00

**\*1\***

Required Date: 18/06/2012 Req'd Qty: 1.00

**\*1\***

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp11-Weld D2744 Cap as per Dwg D2750 and QSI 004. Fill grooves in bend left  
from bending as per QSI 004A/R Aluminum Rod batch: M1221308/6/12/24

12-Grind welds flush as per Dwg D2750

120

**\*120\***

QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

5/17/06/78

Memo

130

**\*130\***

QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

5/17/06/78

Memo

0.00

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**\*85138\***

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Item ID: D350-636-011

Accept

**\*N900040100\***

Setup

Start

**\*NS1\***

Revision ID:

Item Name: Skidtube LH

Stop

**\*NS2\***

Start Date: 04/06/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 18/06/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140 <b>*140*</b> HandFinish	Chemical Conversion Coat per QSI005 4.1	0.00				1		767	12-07-03
Hand Finishing	Memo	0.00							
150 <b>*150*</b> QC	QC7-Inspect Chemical Conversion Coat	0.00							
Quality Control	Memo	0.00							

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action		Section B	Verification Section C	Approval Chief Eng	Approval QC Inspector
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Item ID: D350-636-011

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**\*N900040100\***

Setup

Start

**\*NS1\***

Revision ID:

Item Name: Skidtube LH

Stop

**\*NS2\***

Start Date: 04/06/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 18/06/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160		0.00							
<b>*160*</b>	Skidtubes								
Skidtubes	Memo	0.00							
Skidtubes	1-Open up holes of Detail C and ground handling to 0.625" (total of 8 holes per side) as per dwg D2750.								
	2-Open up holes of Detail B to 0.750" (total of 4 holes per side) as per dwg D2750.								
	3- Open float hole to 0.500" (4 per side)								
	4-Chamfer holes of Detail B, C, ground handling and float holes per dwg D2750 (welding instructions on sheet 8)								
	5-Deburr and blow out all chips from inside of tube								
	6- Prepare tube for welding, remove alodine as required.								
	7-Bond web D2739 in place as per QSI 015 A/R Sikaflex-291 batch: <u>121409</u> exp. date: <u>13-4-12</u>								
	8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 & QSI004 (welding instructions on sheet 8)								
	A/R Aluminum Rod batch: <u>1122130</u>								
	9- At section AJ-AJ drill out x-bolt spacer to 0.404"								
	10-Grind welds flush as per Dwg D2750								

DC 12/07/03

&gt; BE 12/07/05

BE 12/07/06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**\*85138\***

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Item ID: D350-636-011

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Item Name: Skidtube LH

Stop

**\*NS2\***

Start Date: 04/06/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 18/06/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp11-Spot face ground handling holes section (total of 4 places per side) as per  
dwg D2750

8E12/07/06

12-Deburr holes

170

QC10- Inspect visual per QSI004- ground welds

0.00

8.7 (07/09)

**\*170\***

QC

Memo

Quality Control

180

QC5- Inspect part completeness to step on W/O

0.00

8.2 (07/09)

**\*180\***

QC

Memo

Quality Control

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Revision ID:

Item Name: Skidtube LH

Start Date: 04/06/2012 Start Qty: 1.00

Accept

**\*85138\***

Required Date: 18/06/2012 Req'd Qty: 1.00

**\*1\*****\*N900040100\***

Setup

Start

**\*NS1\***

Stop

**\*NS2\***

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

190

**\*190\***

HandFinish

Hand Finishing

Pressure Wash per QSI005 4.3

0.00

1

JG 12.79

200

**\*200\***

Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

1X0

MK  
12/07/09

W121841

Memo

9:30

0.00

START TIME:

3200°F

OVEN TEMPERATURE:

10:00

FINISH TIME:

210

**\*210\***

QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

Inspect for foreign object per QSI 024

1 W1 d 12 12/07/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**Work Order ID 85138**

June-04-12 1:25:41 PM

**\*85138\***

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Item ID: D350-636-011

Accept

**\*N900040100\***

Setup

Start

**\*NS1\***

Revision ID:

Item Name: Skidtube LH

Stop

**\*NS2\***Start Date: 04/06/2012 Start Qty: 1.00 **\*1\***

Cust Item ID:

Required Date: 18/06/2012 Req'd Qty: 1.00 **\*1\***

Customer:

Reference:

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	<b>*NR1*</b>
	QC:	Date:	SPC (Y/N):	Date:		Stop	<b>*NR2*</b>

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
270 <b>*270*</b> Packaging	Packaging  Memo Package as per PPP D350-636-011	0.00							<i>6/27/12 C</i>

280 <b>*280*</b> QC Quality Control	QC21- Final Inspection - Work Order Release  Memo	0.00							<i>MCJ 12/07/13</i>
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*MCJ 12/07/13*

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

June-04-12 1:25:45 PM

Work Order ID: 85138

Parent Item: D350-636-011

Parent Item Name: Skidtube LH

\*85138\*  
\*D350-636-011\*

Start Date: 04/06/2012

Required Date: 18/06/2012

Start Qty: 1.00

Required Qty: 1.00

Page 1

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**Comments:**

IPP Rev:I 02.09.25 Rearranged procedure steps KJ  
 IPP Rev:J 06-03-23 As per Rev D JLM  
 IPP Rev:K 06-07.13 As per dsi9343 EC  
 IPP Rev:L 07-07-28 Added SS Wearplates(Rev E) JLM Verf:EC  
 IPP Rev:M 08-04-22 update steps 4, 13 DD verified by:EC  
 IPP Rev:N 08-09-23 revF as per dwg DD verified by:ec  
 IPP Rev:O 09-02-06 apply antiseize on AN8C21A bolts as per PAR09-010  
 DD verf:EC IPP Rev:P 10.06.22 revise  
 seq110 DD verf:EC IPP Rev:Q 10.10.01 as per IIN revH  
 DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D3492-1		Manufactured	No		230	Each	257.0000	8	8	8	8		
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**\*D3492-1\***

Plug

Location	Loc Qty	Loc Code
----------	---------	----------

FP002	242	
69531	8	
74444	2	
76235	4	
<u>83259</u>	228	X8

FP-A	15	
83098	15	

D3492-3		Manufactured	No		230	Each	167.0000	8	8	8	8	
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**\*D3492-3\***

Plug

Location	Loc Qty	Loc Code
----------	---------	----------

FP-A	167	
81967	5	
83099	40	
<u>83529</u>	122	V8

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**Picklist Print**

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**Work Order ID:** 85138**Parent Item:** D350-636-011**Parent Item Name:** Skidtube LH**\*85138\***  
**\*D350-636-011\*****Start Date:** 04/06/2012**Required Date:** 18/06/2012**Start Qty:** 1.00**Required Qty:** 1.00

NAS1611-010

Purchased

No

230

Each

188.0000

8

8

\*\*

*HL w/loc/10***\*NAS1611-010\***

O-RING

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP001	188	<i>1122151</i>
110915	14	<i>X8</i>
117460	8	
118077	1	
118612	3	
119438	47	
121259	2	
121415	4	
121584	59	
121723	50	

NAS1149D0863J

Purchased

No

250

Each

251.0000

2

2

\*\*

*JB 12/07/11***\*NAS1149D0863J\***

WASHER

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST298	251	
118078	34	
119307	17	
120308	100	<i>120308</i>
121556	100	

D2744

Manufactured

No

110

Each

35.0000

1

1

\*\*

*BB 12/07/20***\*D2744\***

Cap

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
LG002	35	
62715	1	
78900	3	
83412	31	<i>1</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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NOTE: Date & initial all entries

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June-04-12 1:25:49 PM

Work Order ID: 85138

Parent Item: D350-636-011

Parent Item Name: Skidtube LH

\*85138\*  
\*D350-636-011\*

Start Date: 04/06/2012

Required Date: 18/06/2012

Start Qty: 1.00

Required Qty: 1.00

D2600-3-BENT

Manufactured No

110

Each

29.0000

1

1

\*\*

\*D2600-3-BENT\*

Extrusion Bent

8612/06/25

Location	Loc Qty	Loc Code
----------	---------	----------

LG	29	
66875	7	
73253	1	
75021	1	
75022	1	
75023	1	
81330	4	
83305	1	
83442	13	1

D2743

Manufactured No

160

Each

296.0000

8

8

\*\*

\*D2743\*

Crossbolt Spacer

8612/07/04

Location	Loc Qty	Loc Code
----------	---------	----------

LG	222	
81965	55	
83262	167	B
LG001	74	
67766	4	
68251	3	
73403	64	
74445	1	
79517	2	

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

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Page 5

Work Order ID: 85138

Parent Item: D350-636-011

Parent Item Name: Skidtube LH

\*85138\*  
\*D350-636-011\*

Start Date: 04/06/2012

Required Date: 18/06/2012

Start Qty: 1.00

Required Qty: 1.00

ALS4-1032-225

Purchased

No

220

Each

781.0000

38

38

\*\*

HL 1202110

\*AI S4-1032-225\*

Insert

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST281	758	HL122290 X38
108696	146	
110768	62	
118386	55	
118966	68	
121269	427	
ST282	23	
120410	10	
120451	13	

D3793-3

Manufactured

No

230

Each

28.0000

1

1

\*\*

HL 1202110

\*D3793-3\*

Wearshoe

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP001	28	
83394	16	
83901	12	

AN8C35A

Purchased

No

230

Each

68.0000

1

1

\*\*

HL 1202110

\*AN8C35A\*

BOLT

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP002	67	
115960	1	
118286	16	X1
121275	50	
ST346	1	
114442	0	
115188	0	
115960	1	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

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Page 6

Work Order ID: 85138

Parent Item: D350-636-011

Parent Item Name: Skidtube LH

\*85138\*  
\*D350-636-011\*

Start Date: 04/06/2012

Required Date: 18/06/2012

Start Qty: 1.00

Required Qty: 1.00

D3793-1

Manufactured No 230 Each 28.0000 1 1 \*\*

\*D3793-1\*

Wearshoe

Al 120710

Location	Loc Qty	Loc Code
FP001	28	
82171	2	
83393	13	
83903	13	

D3488-041

Manufactured No 230 Each 9.0000 1 1 \*\*

\*D3488-041\*

Blade Fitting Assembly, LH

Al 120710

Location	Loc Qty	Loc Code
FP002	9	B85807
61689	1	
82271	8	

D3794-3

Manufactured No 230 Each 23.0000 1 1 \*\*

\*D3794-3\*

Gasket

Al 120710

Location	Loc Qty	Loc Code
FP	21	
83396	21	
FP002	2	
74530	2	

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

# Picklist Print

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Page 7

Work Order ID: 85138

Parent Item: D350-636-011

Parent Item Name: Skidtube LH

**\*85138\***  
**\*D350-636-011\***

Start Date: 04/06/2012

Required Date: 18/06/2012

Start Qty: 1.00

Required Qty: 1.00

AN6C44A  
**\*AN6C44A\***  
BOLT

Purchased No 230 Each 86.0000 4 4

\*\*

HL 12107110

Location	Loc Qty	Loc Code
FG	2	
103964	2	
ST343	84	
121013	11	
121167	13	
121440	50	X4
121689	10	

MS21083C8  
**\*MS21083C8\***  
NUT

Purchased No 230 Each 81.0000 1 1

\*\*

HL 12107110

Location	Loc Qty	Loc Code
304	75	
121185	29	Y1
121349	46	
FP002	1	
115884	1	
ST303	4	
115884	0	
118077	1	
119309	2	
119638	1	
ST304	1	
121524	1	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

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Work Order ID: 85138

Parent Item: D350-636-011

Parent Item Name: Skidtube LH

**\*85138\***  
**\*D350-636-011\***

Start Date: 04/06/2012

Start Qty: 1.00

Required Date: 18/06/2012

Required Qty: 1.00

D3536-25

Manufactured

No

230

Each

28.0000

1

1

\*\*

**\*D3536-25\***

Gasket

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP	28	
<u>83391</u>	12	
<u>83900</u>	16	

D3631-1

Manufactured

No

230

Each

347.0000

8

8

\*\*

**\*D3631-1\***

Washer

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FG	332	
<u>81874</u>	2	
<u>83588</u>	330	
ST072	15	
68062	2	
75548	13	

D3791-1

Manufactured

No

230

Each

17.0000

1

1

\*\*

**\*D3791-1\***

Wearplate

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP002	17	
<u>62239</u>	2	
<u>83392</u>	15	

AN960C10L

NAS1149C0332

R

Purchased

No

230

Each

0.0000

38

38

11122063

\*\*

**\*AN960C10L\***

washer

(x38) 11122063 11122063

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

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Work Order ID: 85138

Parent Item: D350-636-011

Parent Item Name: Skidtube LH

\*85138\*  
\*D350-636-011\*

Start Date: 04/06/2012

Required Date: 18/06/2012

Start Qty: 1.00

Required Qty: 1.00

D2745

Manufactured

No

230

Each

122.0000

8

8

\*\*

jl 1203110

\*D2745\*

Bushing

Location	Loc Qty	Loc Code
FP	6	
79518	6	
FP001	116	
69529	1	
76142	1	
<u>83260</u>	114	

AN3C5A

Purchased

No

230

Each

1,302.000

34

34

\*\*

jl 1203110

\*AN3C5A\*

Bolt

Location	Loc Qty	Loc Code
FP001	7	
115835	7	
ST350	1295	
116419	28	
117343	13	
117764	7	
117872	2	
119749	23	
120423	28	
121068	12	
<u>121255</u>	500	
121444	182	
121708	500	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Picklist Print**

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Work Order ID: 85138

**\*85138\***  
**\*D350-636-011\***

Parent Item: D350-636-011

Parent Item Name: Skidtube LH

Start Date: 04/06/2012

Required Date: 18/06/2012

Start Qty: 1.00

Required Qty: 1.00

D3537-1

Manufactured No

230

Each

83.0000

3

3

\*\*

JSL 110210

**\*D3537-1\***

Wearpad

Location      Loc Qty      Loc Code

FG	10	1383256
79833	10	13
FP002	73	
69817	5	
81360	14	
81362	19	
83254	1	
83255	3	
84091	31	

NAS1149C0832R

Purchased No

230

Each

257.0000

1

1

\*\*

JSL 110210

**\*NAS1149C0832R\***

WASHER

Location      Loc Qty      Loc Code

ST297	257	
114915	257	VL

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

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Page 11

Work Order ID: 85138

Parent Item: D350-636-011

Parent Item Name: Skidtube LH

**\*85138\***  
**\*D350-636-011\***

Start Date: 04/06/2012

Required Date: 18/06/2012

Start Qty: 1.00

Required Qty: 1.00

AN3C6A	Purchased	No	230	Each	451.0000	4	4	**	<i>SL 1107110</i>
--------	-----------	----	-----	------	----------	---	---	----	-------------------

**\*AN3C6A\***

BOLT

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

FP001	1	
111982	1	
ST351	450	
111982	2	
116419	23	
116549	2	
116704	12	
117619	10	
117688	1	
117872	5	
118422	13	
119449	21	
120423	3	
120693	158	
<u>121682</u>	200	

*SL 1107110*

NAS1611-013	Purchased	No	230	Each	361.0000	8	8	**	<i>SL 1107110</i>
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**\*NAS1611-013\***

O-RING

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

FP001	361	
116582	5	
117291	2	
117887	53	
119623	36	
121584	15	
<u>121825</u>	200	
121826	50	

*SL 1107110*

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

# Picklist Print

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Page 12

Work Order ID: 85138

Parent Item: D350-636-011

Parent Item Name: Skidtube LH

**\*85138\***  
**\*D350-636-011\***

Start Date: 04/06/2012

Required Date: 18/06/2012

Start Qty: 1.00

Required Qty: 1.00

D3535-25

Manufactured No 230 Each 34.0000 1 1 \*\*

**\*D3535-25\***

Wearshoe

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP001	34	
62233	1	
81357	1	
82156	2	
83387	17	
<u>83899</u>	13	<u>Y1</u>

D3794-1

Manufactured No 230 Each 26.0000 1 1 \*\*

**\*D3794-1\***

Gasket

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP	6	
82167	6	
FP002	20	
<u>83395</u>	20	<u>Y1</u>

MS21043-6

Purchased No 230 Each 618.0000 4 4 \*\*

**\*MS21043-6\***

NUT

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FG	20	
103693	20	
ST301	598	
117887	2	
<u>118384</u>	96	<u>Y4</u>
120308	500	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date &amp; initial all entries

# Picklist Print

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Page 13

Work Order ID: 85138

\*85138\*  
\*D350-636-011\*

Parent Item: D350-636-011

Parent Item Name: Skidtube LH

Start Date: 04/06/2012

Required Date: 18/06/2012

Start Qty: 1.00

Required Qty: 1.00

D3493-1

Manufactured No 250 Each 127.0000 2 2 ✓

\*\*

JB  
SK

5 \*D3493-1\*

Washer

Location	Loc Qty	Loc Code
ST050	127	
77573	1	
82023	26	
83097	100	83097

MS21083C8

Purchased No 250 Each 81.0000 2 2 ✓

\*\*

JB  
18

5 \*MS21083C8\*

NUT

Location	Loc Qty	Loc Code
304	75	
121185	29	
121349	46	121349
FP002	1	
115884	1	
ST303	4	
115884	0	
118077	1	
119309	2	
119638	1	
ST304	1	
121524	1	

AN8C21A

Purchased No 250 Each 57.0000 2 2 ✓

\*\*

JB  
10/07/11

\*AN8C21A\*

BOLT

Location	Loc Qty	Loc Code
ST343	57	
118758	3	
121167	4	
121275	50	121275

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

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Page 14

Work Order ID: 85138

\*85138\*  
\*D350-636-011\*

Parent Item: D350-636-011

Parent Item Name: Skidtube LH

Start Date: 04/06/2012

Required Date: 18/06/2012

Start Qty: 1.00

Required Qty: 1.00

NAS1515H3L

Purchased

No

230

Each

146.0000

4

4

\*\*

SL 2107110

\*NAS1515H3I \*

WASHER

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FG	40	
102472	40	
ST277	106	
118686	3	
119438	1	X 4
120360	11	
121243	2	
121556	89	

D2741

Manufactured

No

250

Each

20.0000

1

1

\*\*

83135 JB

\*D2741\*

Blade, 350 Skidtube

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST	-10	
ST466	30	
71856	1	
79516	19	

D3532-1

Manufactured

No

250

Each

7.0000

2

2

\*\*

83319 JB 12/07/11

\*D3532-1\*

Spacer

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST053	7	
82041	7	

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1	1			D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
	4	4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN960C10L	WASHER
1	1	1	1	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS151H3L	WASHER

**GENERAL NOTES:**

- 1) MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- 2) FINISH:  
ACID ETCH, ALONDE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.  
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3.
- 3) BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: N/A
- 7) IDENTIFICATION: N/A
- 8) WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- 9) WELD PER DART QSI 004
- 10) INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES (.0297) FOR WEARSHOE INSERTS  
FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:  
MINIMUM YIELD TENSILE STRENGTH = 35 KSI  
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- 11) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS.  
COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY. CLEAN EXCESS OFF  
POWDER COATING WITH MEK DEGREASER.
- 12) SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL 
- 13) SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

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SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 85138 MLJ

12/06/04

RELEASED  
*65-372-14*

F	INCORPORATE DS1 9413; QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/-3 REPLACES D3535-13/-35 (ZN C8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL). WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON: REF. NCR 08-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS, CHANGE INSERTS; ADD D3631-1; REMOVE QTY (38) NAS151H3L, REMOVE QTY (10) NAS151H8L, REMOVE D2741, QTY (2) AN960C816; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SLOTS FOR APICAL FLOATS; INCORPORATE DEO 913/9157	PH	06.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	98.11.18
B	CHANGE MS24694-S293 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE USA, INC.	
DRAWN		PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2750	SHEET 1 OF 11
APPROVED		TITLE	SCALE
DE APPR.		350 SKIDTUBE ASSEMBLY	NTS
DATE	08.07.16	COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THE DOCUMENT IS THE PROPERTY OF DART AEROSPACE USA, INC. AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES EXCEPT THOSE FOR WHICH IT WAS ISSUED. IT IS THE PROPERTY OF DART AEROSPACE USA, INC. WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

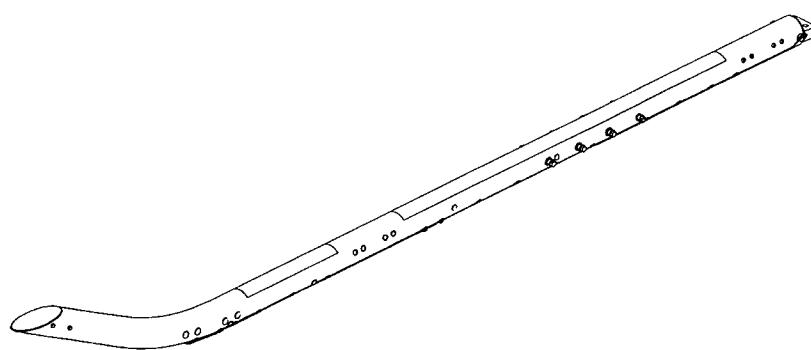
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

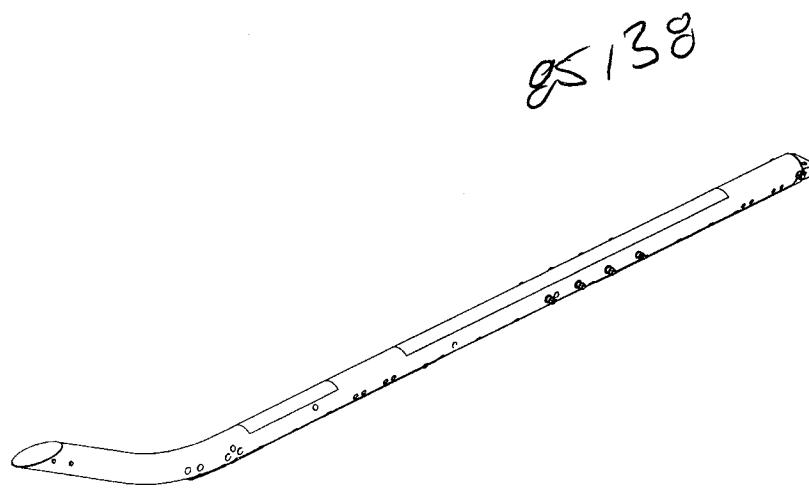
8 7 6 5 4 3 2 1

D

D



D2750-041 350 SKIDTUBE ASSEMBLY, LH



D2750-042 350 SKIDTUBE ASSEMBLY, RH

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*08.07.16*

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CHECKED	<i>PA</i>	DRAWING NO. <b>D2750</b> REV. F
MFG. APPR.	<i>PA</i>	SHEET 2 OF 11
APPROVED	<i>PA</i>	TITLE <b>350 SKIDTUBE ASSEMBLY</b> NTS
DE APPR.	<i>PA</i>	SCALE
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8 7 6 5 4 3 2 1

B

B

A

A

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
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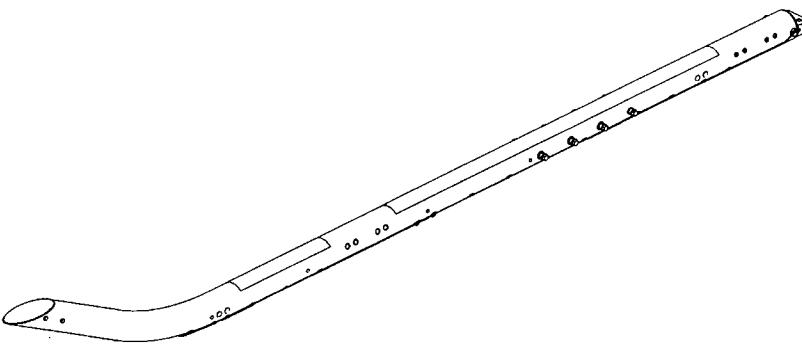
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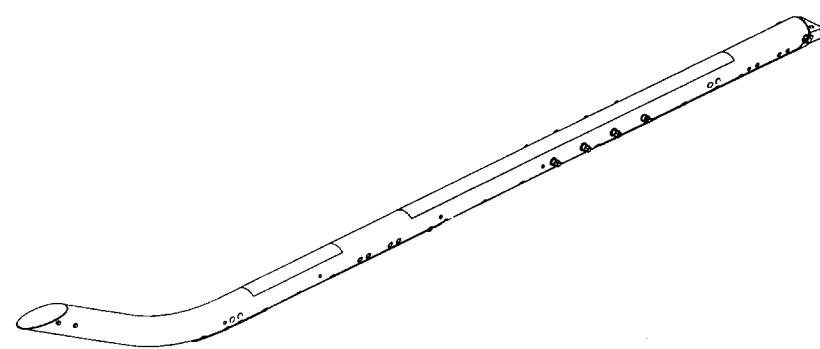
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D



D2750-043 350 SKIDTUBE ASSEMBLY, LH



D2750-044 350 SKIDTUBE ASSEMBLY, RH

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08-09-22/11

DESIGN	<i>PW</i>	DART AEROSPACE USA, INC.
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DE APPR.	<i>JK</i>	SHEET 3 OF 11
DATE	08.07.16	TITLE
		SCALE
		350 SKIDTUBE ASSEMBLY
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8 7 6 5 4 3 2 1

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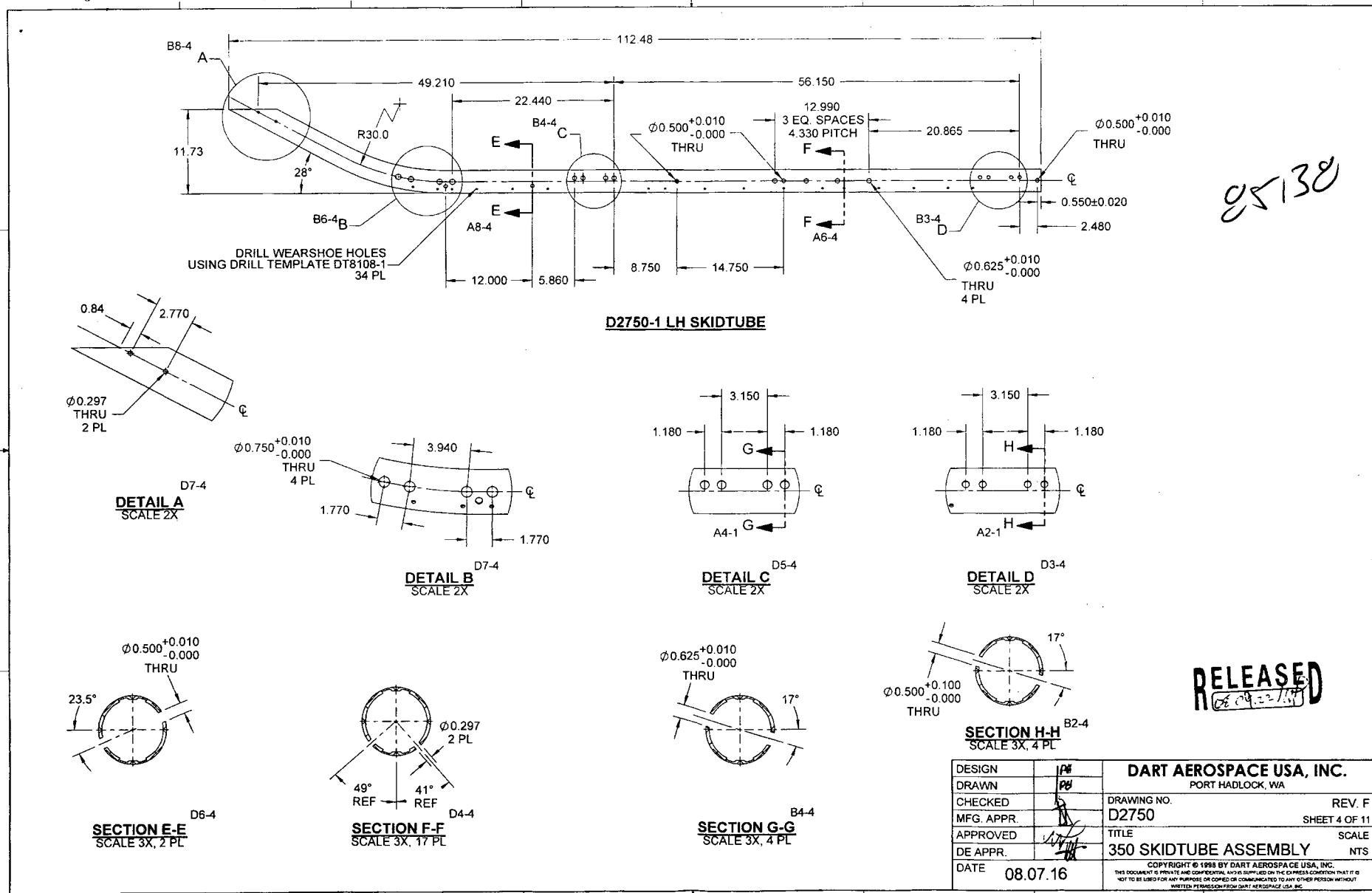
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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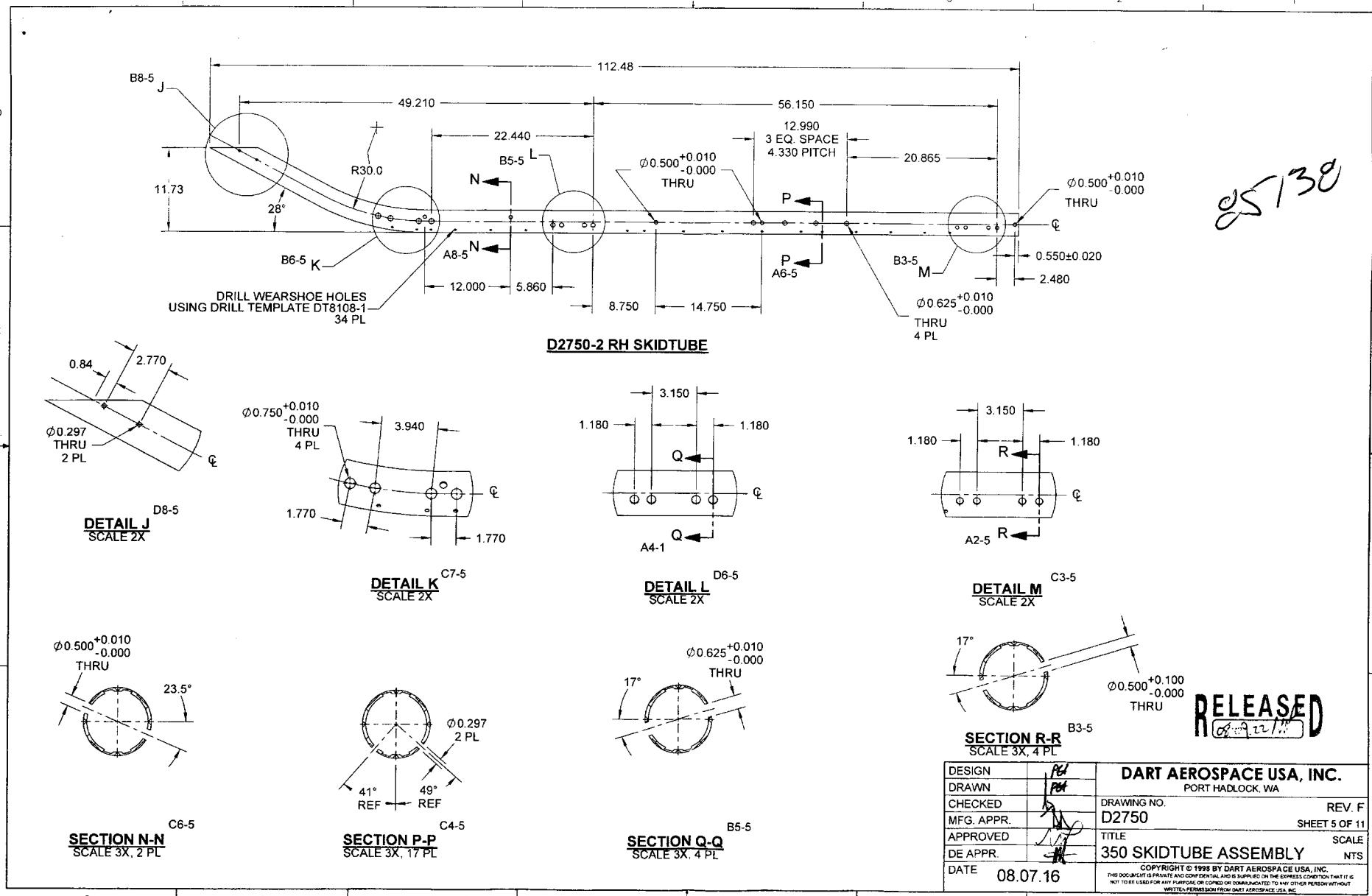
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DESIGN	RE	DART AEROSPACE USA, INC.
DRAWN	PA	PORT HADLOCK, WA
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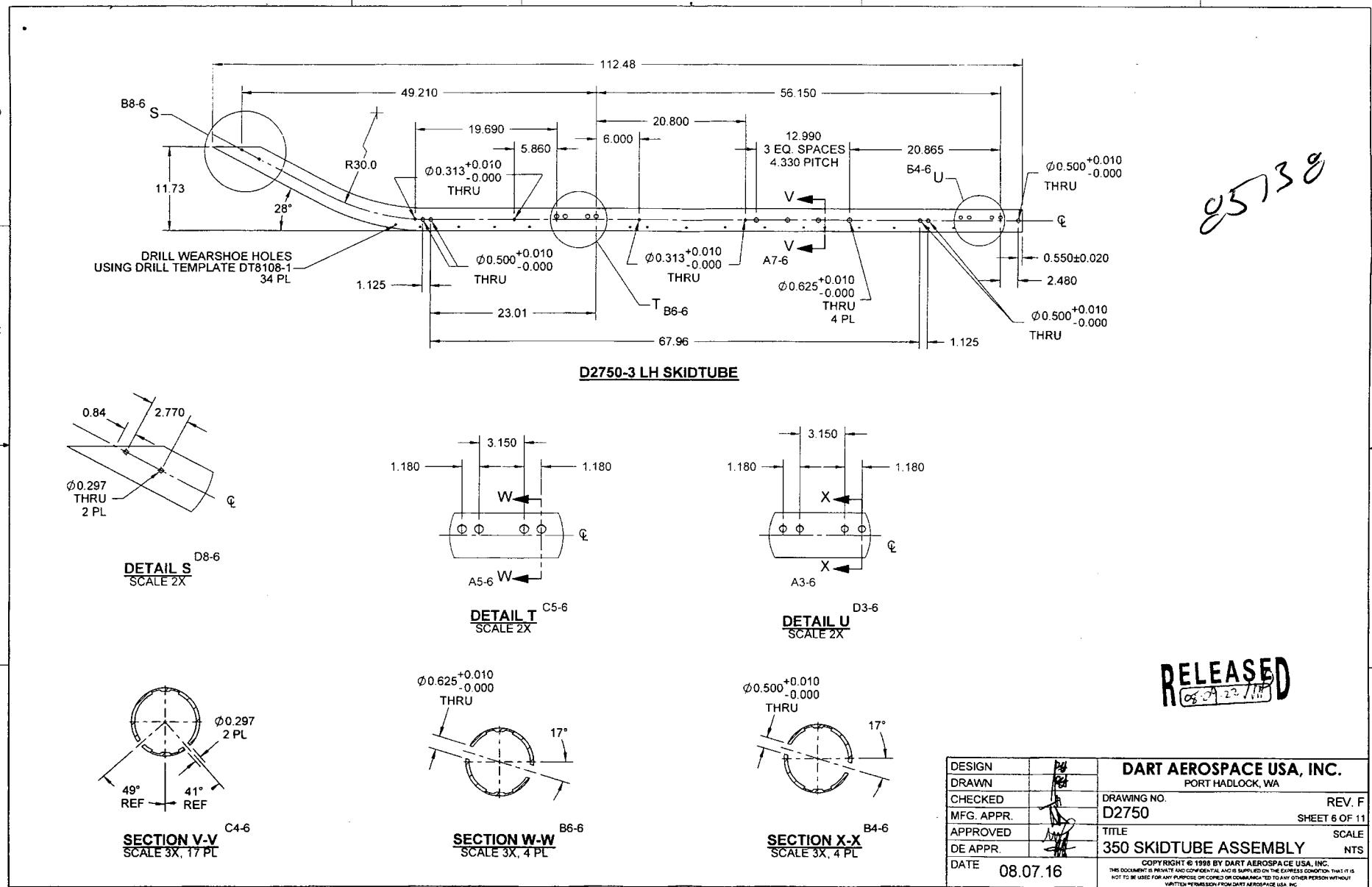
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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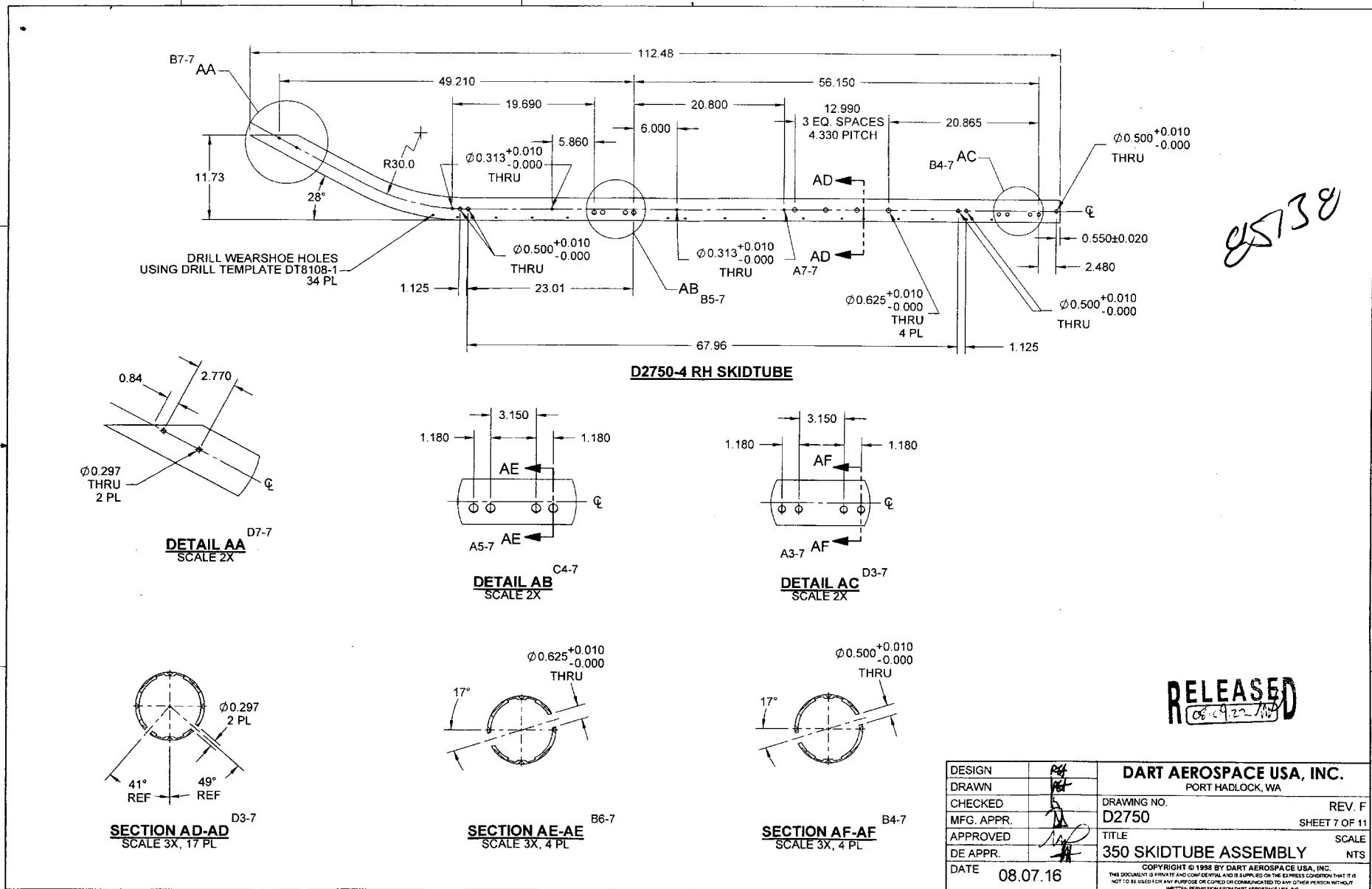
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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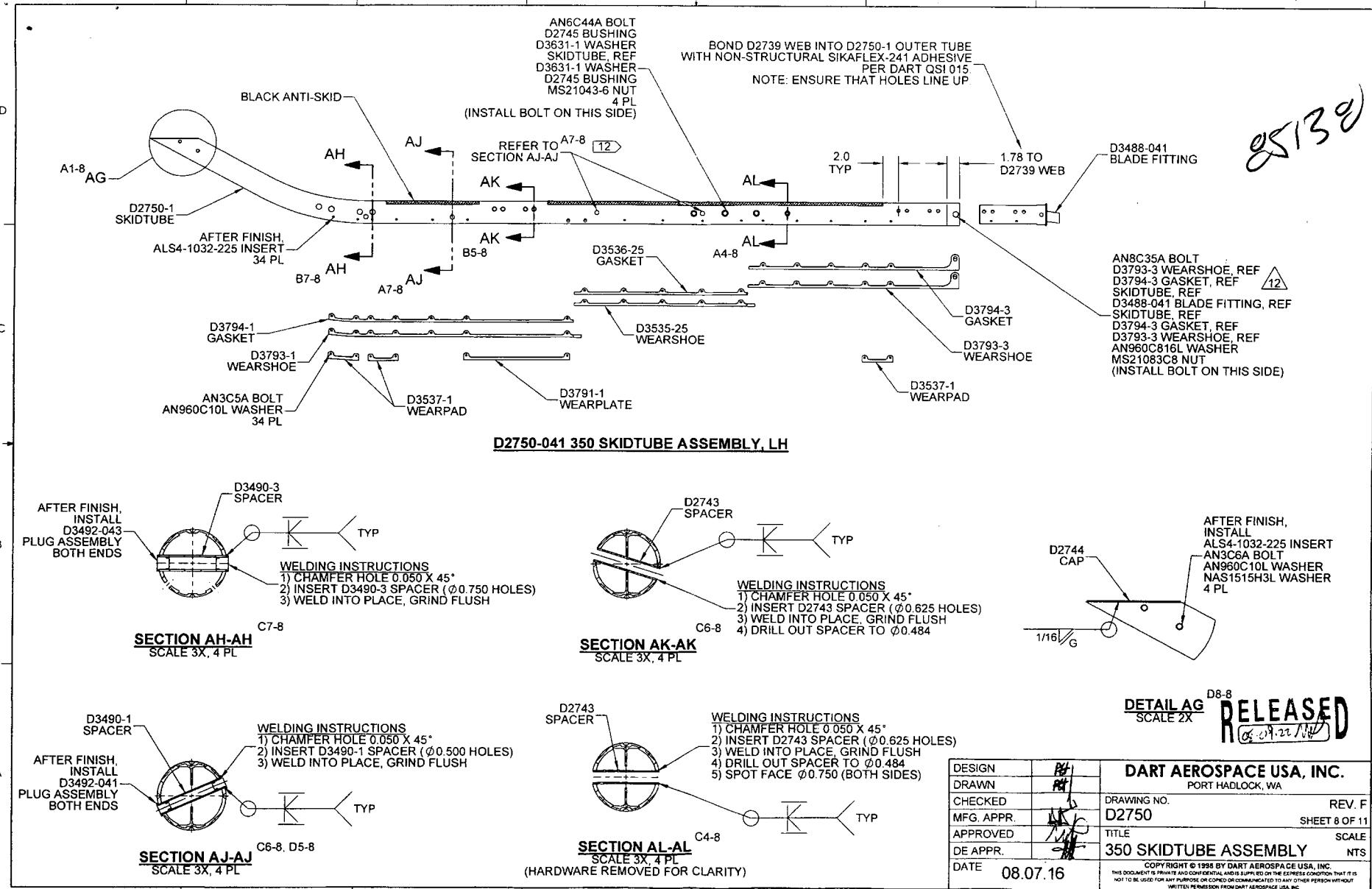
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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85138

AN8C35A BOLT  
D3793-3 WEARSHOE, REF  
D3794-3 GASKET, REF   
SKIDTUBE, REF  
D3488-041 BLADE FITTING, REF  
SKIDTUBE, REF  
D3794-3 GASKET, REF  
D3793-3 WEARSHOE, REF  
AN960C816L WASHER  
MS21083C8 NUT  
(INSTALL BOLT ON THIS SIDE)

**D2750-041 350 SKIDTUBE ASSEMBLY, LH**

B

AFTER FINISH,  
INSTALL  
D3492-043  
PLUG ASSEMBLY  
BOTH ENDS

D3490-3  
SPACER

TYP

WELDING INSTRUCTIONS

- 1) CHAMFER HOLE 0.050 X 45°
- 2) INSERT D3490-3 SPACER ( $\varnothing$  0.750 HOLES)
- 3) WELD INTO PLACE, GRIND FLUSH

C7-8

**SECTION AH-AH**

SCALE 3X, 4 PL

A

D3490-1 SPACER

AFTER FINISH, INSTALL D3492-041 PLUG ASSEMBLY BOTH ENDS

WELDING INSTRUCTIONS

1) CHAMFER HOLE 0.050 X 45°  
 2) INSERT D3490-1 SPACER (Ø 0.500 HOLES)  
 3) WELD INTO PLACE, GRIND FLUSH

TYP

SECTION AJ-AJ

SCALE 3X 1:10

**WELDING INSTRUCTIONS**

- 1) CHAMFER HOLE 0.050 X 45°
- 2) INSERT D2743 SPACER (Ø.625 HOLES)
- 3) WELD INTO PLACE, GRIND FLUSH
- 4) DRILL OUT SPACER TO Ø.484
- 5) SPOT FACE Ø.750 (BOTH SIDES)

**SECTION AL-AL**  
SCALE 3X, 4 PL  
HARDWARE REMOVED FOR CLARITY)

**C4-8**

**TYP**

**DETAIL AG** D8-8  
SCALE 2X **RELEASED** *(6-19-22)*

DESIGN	PS	DART AEROSPACE USA, INC.	
DRAWN	PS	PORT HADLOCK, WA	
CHECKED			
MFG. APPR.	JK	DRAWING NO.	REV. F
APPROVED	JK	D2750	SHEET 8 OF 11
DE APPR.	JK	TITLE	SCALE
DATE	08.07.16	350 SKIDTUBE ASSEMBLY	

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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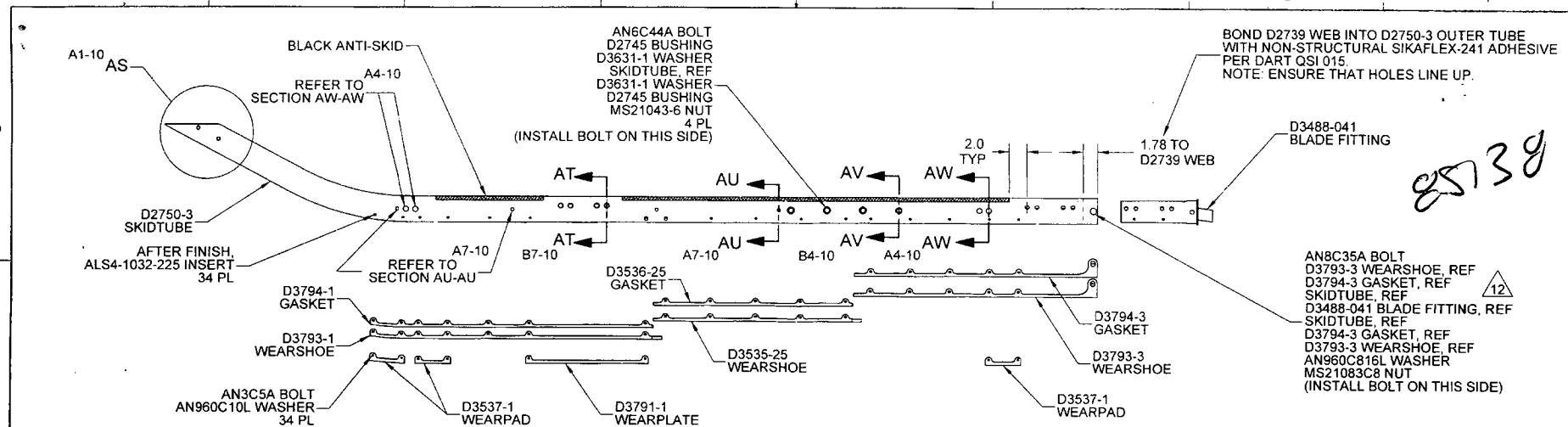
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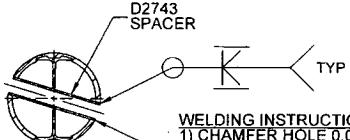
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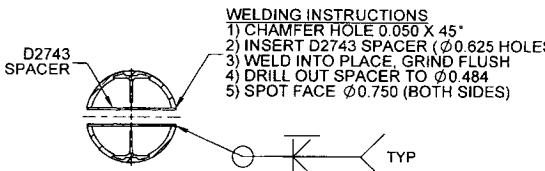


D2750-043 350 SKIDTUBE ASSEMBLY, LH

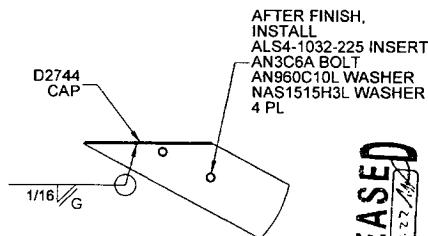


WELDING INSTRUCTIONS  
1) CHAMFER HOLE 0.050 X 45°  
2) INSERT D2743 SPACER (Ø 0.625 HOLES)  
3) WELD INTO PLACE, GRIND FLUSH  
4) DRILL OUT SPACER TO Ø 0.484

SECTION AT-AT  
SCALE 3X, 4 PL



WELDING INSTRUCTIONS  
1) CHAMFER HOLE 0.050 X 45°  
2) INSERT D2743 SPACER (Ø 0.625 HOLES)  
3) WELD INTO PLACE, GRIND FLUSH  
4) DRILL OUT SPACER TO Ø 0.484  
5) SPOT FACE Ø 0.750 (BOTH SIDES)

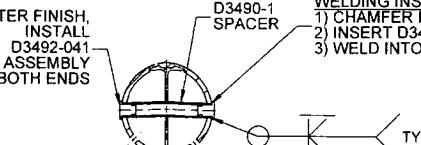


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08/07/16



WELDING INSTRUCTIONS  
1) CHAMFER HOLE 0.050 X 45°  
2) INSERT D3490-5 SPACER (Ø 0.313 HOLES)  
3) WELD INTO PLACE, GRIND FLUSH

SECTION AU-AU  
SCALE 3X, 4 PL



WELDING INSTRUCTIONS  
1) CHAMFER HOLE 0.050 X 45°  
2) INSERT D3490-1 SPACER (Ø 0.500 HOLES)  
3) WELD INTO PLACE, GRIND FLUSH

SECTION AW-AW  
SCALE 3X, 4 PL

DESIGN	<i>✓</i>	DART AEROSPACE USA, INC.
DRAWN	<i>✓</i>	PORT HADLOCK, WA
CHECKED	<i>✓</i>	DRAWING NO.
MFG. APPR.	<i>✓</i>	D2750
APPROVED	<i>✓</i>	REV. F
DE APPR.	<i>✓</i>	SHEET 10 OF 11
DATE	08.07.16	TITLE
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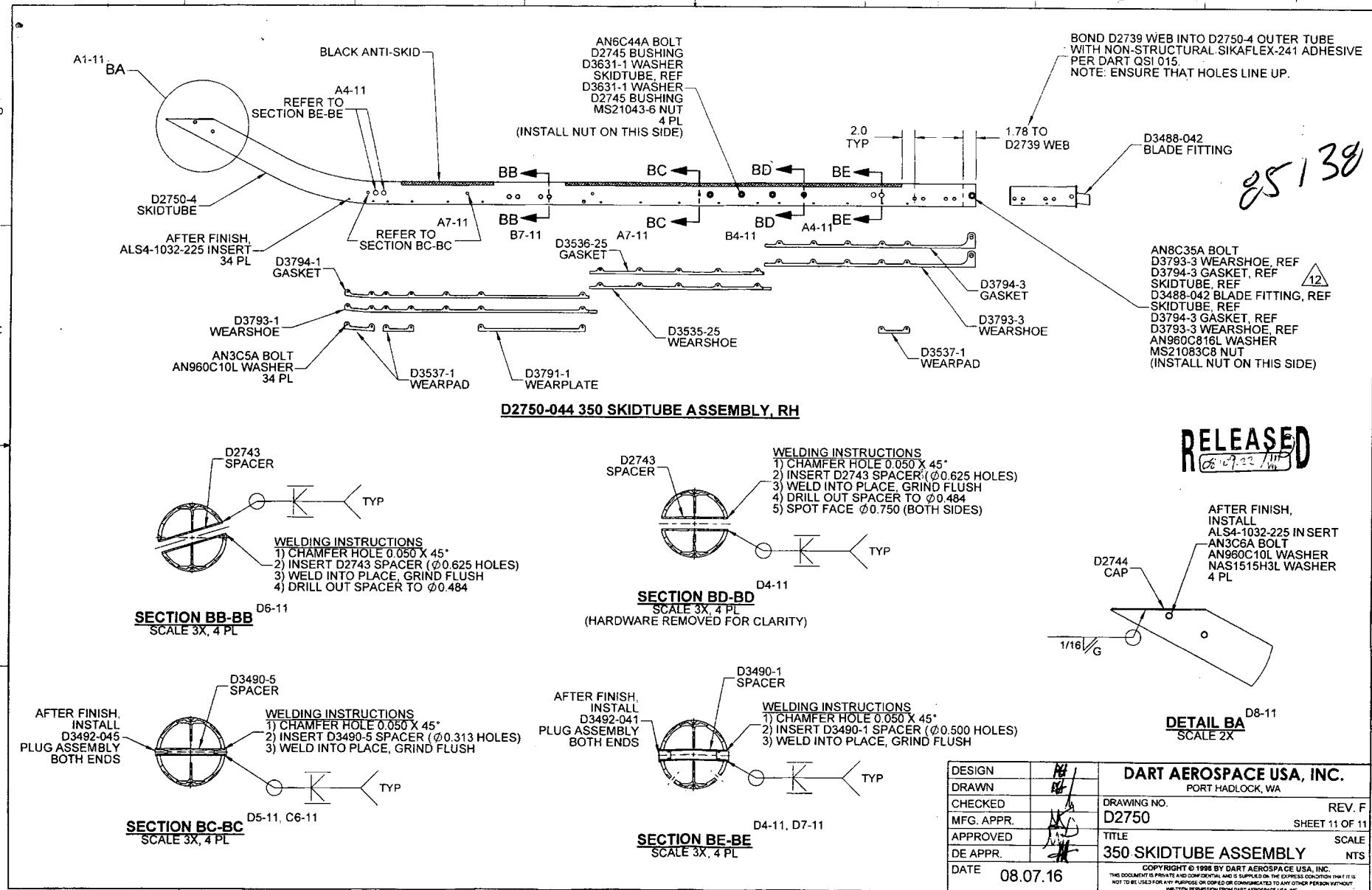
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W/O:

## WORK ORDER CHANGES

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NO. 294

AWS D17.1.2001  
QUALIFICATION TEST RECORD

Name: Barclay Elliott  
Job number: 83800  
Part number: 1350-636-012  
Description: Skid Hub  
Welding Process: Tig  Mig   
Base material: Alum  
Current: AC  DC

TEST REQUIREMENTS AND RESULTS

Visual: pass  fail   
Penetration: pass  fail

UNACCEPTABLE

Cracks: pass  fail   
Undercut: pass  fail   
Pin holes: pass  fail   
Overlap (cold lap) pass  fail   
Porosity (surface): pass  fail   
Coloration: pass  fail

Qualifier David Ainsal Date of Test Coupon 2.05.09

Welder Barclay Elliott Date of Test Coupon 12.05.09

The above named individual is qualified in accordance with AWS D17.1.2001 to weld